

Work Order ID 86527

Wednesday, July 04, 2012 9:24:05 AM

86527

Ship Friday

Page 1

Item ID: D3295-041

Accept

N900040100

Setup Start ***NS1***

Revision ID:

Item Name: Floor Window

Stop ***NS2***

Start Date: 7/4/2012 Start Qty: 4.00

4

Cust Item ID:

Required Date: 7/6/2012 Req'd Qty: 4.00

4

Customer:

Reference:

Approvals: Process Plan: *NKF*

Date: *12-07-01*

Tooling:

Date:

Run Start ***NR1***

QC:

Date:

SPC (Y/N):

Date:

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr	Revision Nbr
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D3295	Rev D
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100

0.00

100

FLOW WATER JET

Waterjet

Memo

0.00

FLOW CNC Waterjet

1-Cut as per Dwg D3295 Dwg Rev: *D* Prog Rev: *D* 2-
Remove plastic and wrap in saran wrap. 2-Deburr if necessary

4 0 Jm 12-7-4

110

QC2- Inspect parts off machine FAI/FAIB

0.00

110

QC

Memo

0.00

Quality Control

4 0 Jm 12-7-4

120

QC8- Inspect parts - second check

0.00

120

QC

Memo

0.00

Quality Control

5/26/10

(Signature)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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NOTE: Date & initial all entries

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Approvals: Process Plan:

Date:

Tooling:

Date:

Run Start ***NR1***

QC:

Date:

SPC (Y/N):

Date:

Stop ***NR2***Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

130

130

Small Fab

Small Fab

Memo

0.00

0.00

Small Fab

Assemble as per Dwg D3295. Put window in plastic wrap.

140

140

QC

Quality Control

QC5- Inspect part completeness to step on W/O

Memo

0.00

0.00

150

150

Packaging

Packaging

Identify as per dwg & Stock Location:

Memo

0.00

0.00

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Customer:

Reference:

Approvals: Process Plan: _____ Date: _____

Tooling: _____ Date: _____

Run Start ***NR1***

QC: _____ Date: _____

SPC (Y/N): _____ Date: _____

Stop ***NR2***Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

160

QC21- Final Inspection - Work Order Release

0.00

160

QC

Memo

0.00

Quality Control

*OK 12/7/9**ME
12-07-09*

W/O:		WORK ORDER CHANGES					
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Picklist Print

Wednesday, July 04, 2012 9:24:04 AM

Page 1

Work Order ID: 86527
 Parent Item: D3295-041
 Parent Item Name: Floor Window

Start Date: 7/4/2012 Required Date: 7/6/2012
 Start Qty: 4.00 Required Qty: 4.00

Comments: IPP C05.06.20D3295-1 no longer made in-houseKJ/JLM
 IPP Rev:D Added DT8822 07-03-20 JLM
 IPP Rev:E Returned Manufacturing In House 07-06-26 JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D2728-1		Manufactured	No			100	Each	0.0000	0	0			
Dart Logo label													
MLEXS.125-9034-01		Purchased	No			140	sf	188.8000	1.24	5.2210526			
1/8" 9034 Lexan Sheet													

Im 12-74

Location	Loc Qty	Loc Code
MAT019	188.8	
117273	106.9	
119591	81.9	

HA591

119591

+

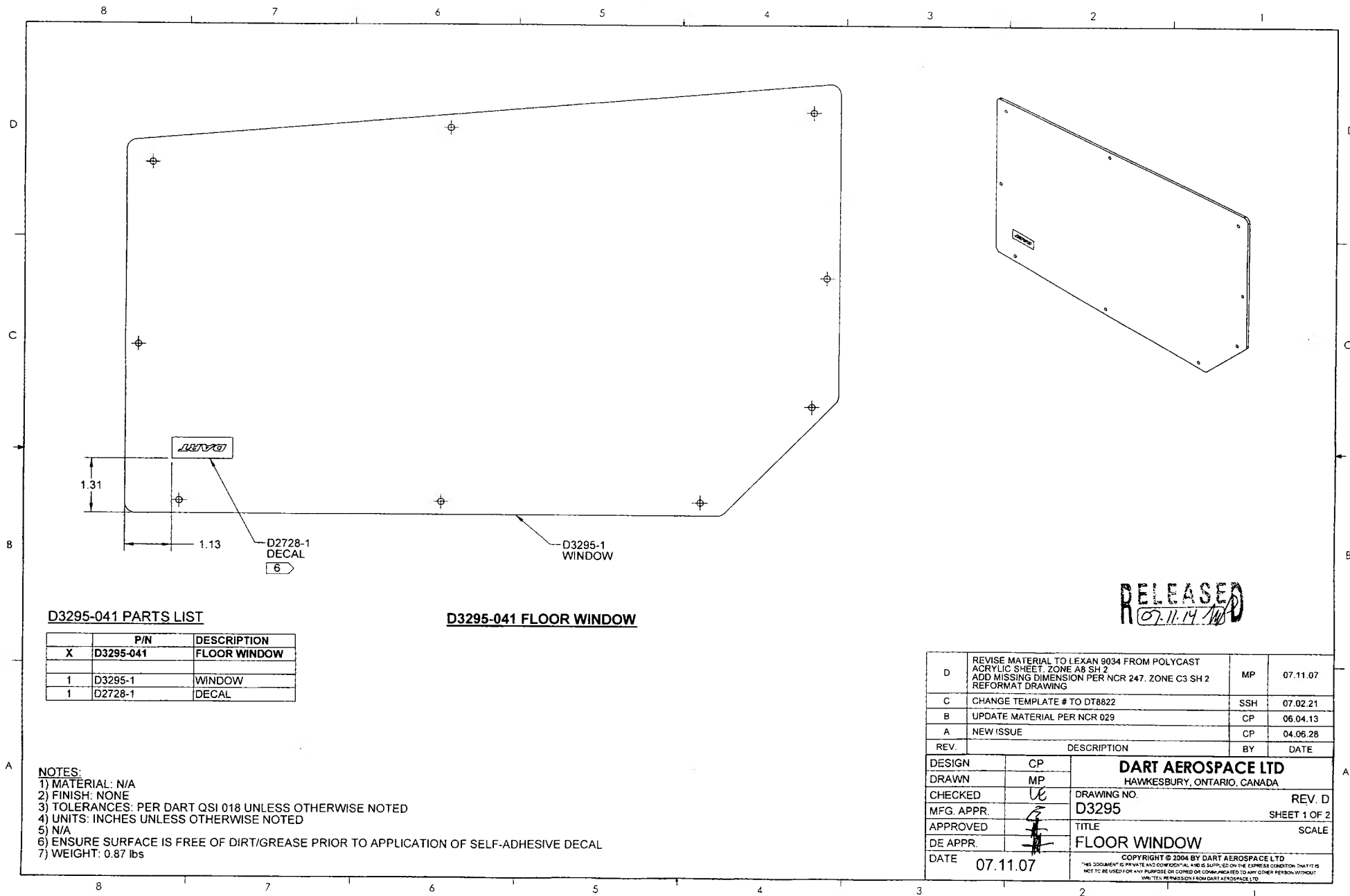
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D3295-041 PARTS LIST

	P/N	DESCRIPTION
X	D3295-041	FLOOR WINDOW
1	D3295-1	WINDOW
1	D2728-1	DECAL

D3295-041 FLOOR WINDOW

NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) N/A
- 6) ENSURE SURFACE IS FREE OF DIRT/GREASE PRIOR TO APPLICATION OF SELF-ADHESIVE DECAL
- 7) WEIGHT: 0.87 lbs

RELEASED
07.11.14

D	REVISE MATERIAL TO LEXAN 9034 FROM POLYCAST ACRYLIC SHEET. ZONE A8 SH 2 ADD MISSING DIMENSION PER NCR 247. ZONE C3 SH 2 REFORMAT DRAWING	MP	07.11.07
C	CHANGE TEMPLATE # TO DT8822	SSH	07.02.21
B	UPDATE MATERIAL PER NCR 029	CP	06.04.13
A	NEW ISSUE	CP	04.06.28
REV.	DESCRIPTION	BY	DATE
DESIGN	CP	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	MP		
CHECKED	UC	DRAWING NO.	REV. D
MFG. APPR.	UC	D3295	SHEET 1 OF 2
APPROVED	UC	TITLE	SCALE
DE APPR.	UC	FLOOR WINDOW	
DATE	07.11.07	<small>COPYRIGHT © 2004 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSES OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small>	

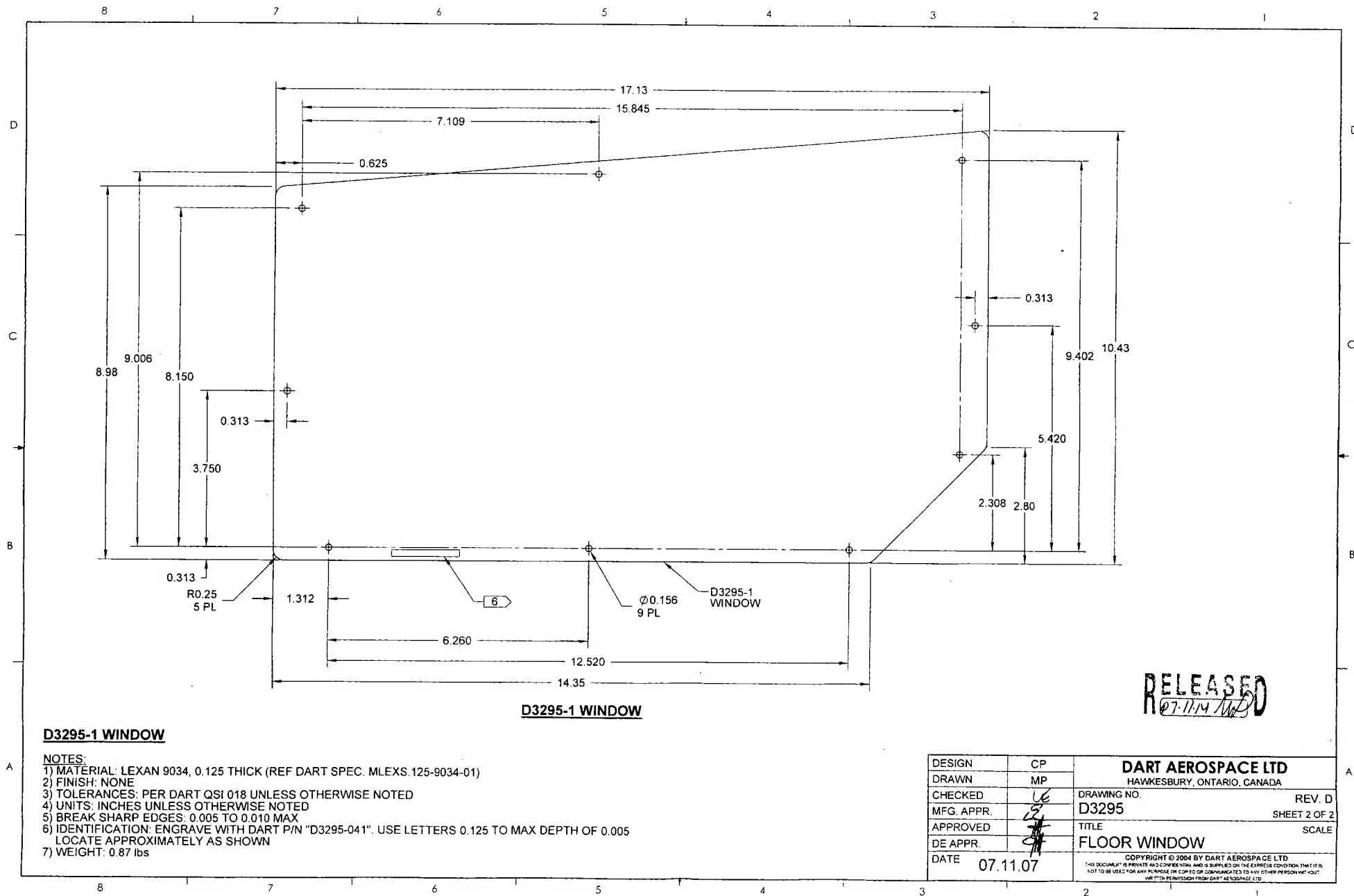
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DART AEROSPACE LTD		Work Order: 86527
Description: Window		Part Number: D3295
Inspection Dwg: D3295	Rev: D	Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
Ø0.156	+0.005/-0.001	0.157"	✓		✓	mm01
17.13	+/-0.030	17.13"	✓		mt	tu301
10.43	+/-0.030	10.435"	✓		✓	ProdW302
14.35	+/-0.030	14.35"	✓		mt	tu301
8.98	+/-0.030	8.982"	✓		✓	ProdW302
0.625	+/-0.010	0.625"	✓		✓	mm01
7.109	+/-0.010	7.114"	✓		✓	mt
15.845	+/-0.010	15.845"	✓		mt	tu301
2.308	+/-0.010	2.312"	✓		✓	mm01
5.420	+/-0.010	5.422"	✓		✓	"
9.402	+/-0.010	9.407"	✓		✓	ProdW302
1.312	+/-0.010	1.309"	✓		✓	mm01
6.260	+/-0.010	6.265"	✓		✓	"
12.520	+/-0.010	12.520"	✓		mt	tu301
0.313	+/-0.010	0.313"	✓		✓	mm01
3.750	+/-0.010	3.752"	✓		✓	"
8.150	+/-0.010	8.153"	✓		✓	ProdW302
9.006	+/-0.010	9.009"	✓		✓	ProdW302
0.125	+/-0.010	0.116"	✓		✓	mm01

Measured by: SM	Audited by: S	Prototype Approval:	N/A
Date: 12-7-4	Date: 12/6/05	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	07.11.23	New Issue	KJ/EC/DD	

Dart Aerospace Ltd

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